

Work Order ID 84503

May-15-12 10:36:35 AM

RUSH

84503

Page 1

Item ID: D3403-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 15/05/2012 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 22/05/2012 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3403	D								

100
100
 Hardinge
 Hardinge CNC Lathe Small
 Operation: Hardinge CNC LATHE SMALL
 Set Up/Run Hours: 0.00
 Memo: 1- Turn as per Folio FA558 & Dwg D3403
 Folio Rev: 4/A Dwg Rev: 4
 2-Deburr
 30 ϕ
SL 12/5/16

110
110
 QC
 Quality Control
 Operation: QC2- Inspect parts off machine FAI/FAIB
 Set Up/Run Hours: 0.00
 Memo:
 30 ϕ
12/5/16

120
120
 QC
 Quality Control
 Operation: QC8- Inspect parts - second check
 Set Up/Run Hours: 0.00
 Memo:
 30 ϕ
B.A 12/05/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3403-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 15/05/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: ST 42.

0.00

130

Packaging

Memo

0.00

Packaging

30x

SP

12-5-17.

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/5/17 JA
mw 12/05/17

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Picklist Print

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Page 1

Work Order ID: 84503

84503

Parent Item: D3403-3

D3403-3

Parent Item Name: Bushing

Start Date: 15/05/2012

Required Date: 22/05/2012

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP Rev:A05.08.31New issueKJ/JLM

IPP Rev:B 06-03-07 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R0.750

Purchased

No

100

f

119.7560

0.206

6.505263

M303R0 750

**

8.5 12/5/16

303 Round Bar 0.750

Location

Loc Qty

Loc Code

MAT028

119.756

117328

13.242

117798

4.004

118509

4.08

119346

0.645

120145

10.566

121070

1.1

121157

25.619

121282

12.5

121728

48

6.5 2.5

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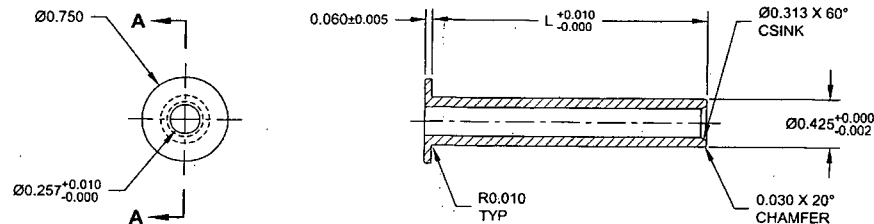
Dart Aerospace Ltd

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SECTION A-A

D3403-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3403-1	2.416	0.07
D3403-3	2.165	0.06
D3403-5	2.440	0.07

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
PER ASTM A582
REF. DART SPEC. M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84503 MLC
12/05/15

RELEASED
2011-10-31
WJ

D	FOR -5, 2.440 WAS 2.500 (PER PAR 11-125)	XDF	11.10.28
C	REFORMAT TO CURRENT STD PER QSI 043; ADDED D3403-5. TOL WAS +0.005/-0.000. REASON: PAR#10-029	MB	10.04.21
B	ADD COUNTERSINK	PH	06.01.23
A	NEW ISSUE	PH	05.03.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3403** REV. **D**
SHEET 1 OF 1
TITLE **BUSHING** SCALE **NTS**

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